



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2933-1BL
Job Sheet 167805-A



Part No: D2933-1BL

Job Qty: 5 ea

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Job Created: 12/12/17

Due Date: 11/24/17

Type: SOLD

Ship Via:

Status: Scheduled

Priority: High

Job Tracking No:

Created By: Linda Lacelle

Description:

See job b # 172306. Not painted blue.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
130	QC	5 pcs		11/23/17	0.00	0.00	QC8 Machining-1		
140	HandFinish	5 pcs		11/24/17	0.00	0.47	HandFinish1		
150	Outsource	5 pcs		11/24/17			ATE003-VC		
160	QC	5 pcs		11/24/17	0.00	0.00	QC14		
170	Packaging	5 pcs		11/24/17	0.00	0.00	Packaging3-1		
180	QC21-SA	5 Ea		11/24/17	0.00	0.00	QC21		

Part Op Descriptions: **150 - *** MASK ALL HOLES AS PER PAR16-484***** BATCH: _____ ISSUE PO _____

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 12/12/17 9:20 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2933-1BL
Job Sheet 167805



split
(5)

Part No: D2933-1BL

Job Qty: 10 ea

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/24/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Rev C.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Machining		<i>FK 17-12-4</i>
100	CNC Vertical Machining	10 pcs	11/23/17	11/23/17	0.24	8.58	HAAS 1		<i>SBL 17/12/06</i>
110	Mill Conv	10 pcs	11/23/17	11/23/17	0.00	8.57	Mill Conv 1		<i>SBL 17/12/06</i>
120	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC1		<i>SBL 17/12/06</i>
130	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC8		<i>S.P. 14-12-11</i>
140	HandFinish	10 pcs	11/23/17	11/23/17	0.00	0.94	HandFinish1		
150	SprayPaint	10 pcs	11/24/17	11/24/17	0.00	0.55	Spray Paint		
160	QC	10 pcs	11/24/17	11/24/17	0.00	0.00	QC14		
170	Packaging	10 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3		
180	QC21-SA	10 Ea	11/24/17	11/24/17	0.00	0.00	QC21		

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - *** MASK ALL HOLES AS PER PAR16-484*** BATCH: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-001	10	29	0	0

5016627 x 7
5016623 x 3

Part Specifications

Specifications could not be found.

Plex 11/7/17 8:20 AM dart.Michaud-Febrille.Victoria

DART AEROSPACE LTD		Work Order:	167805
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933	Rev: C	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.120	.121	.120	.120	.120
B	0.100	0.140		.122	.122	.119	.121	.119
C	0.100	0.140		.125	.125	.125	.125	.125
D	0.210	0.230		.222	.221	.221	.221	.221
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.511	.511	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257
L	0.312	0.317		.312	.312	.312	.312	.312
M	0.235	0.240		.239	.238	.238	.238	.238
N	0.100	0.140		.123	.122	.122	.122	.121
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.500	.500	.500	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.490	2.494	2.492	2.494	2.494
S	0.240	0.270		.252	.252	.252	.252	.252
T	0.100	0.180		.140	.133	.140	.138	.138
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.125	1.145		1.134	1.135	1.135	1.136	1.136
Y	1.565	1.585		1.575	1.575	1.575	1.575	1.575
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: SBL / JLP	Date: 17/12/06
Audited by: B-e	Date: 14-12-11
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

DART AEROSPACE LTD		Work Order:	167805
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Inspection Dwg: D2933	Rev: C	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				#5	#7	#8	#9	#10
A	0.100	0.140		.120	.120	.121	.121	.121
B	0.100	0.140		.120	.122	.120	.120	.121
C	0.100	0.140		.125	.125	.125	.126	.125
D	0.210	0.230		.221	.221	.221	.221	.221
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.511	.511	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257
L	0.312	0.317		.312	.312	.312	.312	.312
M	0.235	0.240		.238	.238	.238	.238	.239
N	0.100	0.140		.121	.122	.120	.121	.121
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.500	.500	.500	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.493	2.492	2.490	2.494	2.493
S	0.240	0.270		.251	.251	.251	.251	.251
T	0.100	0.180		.138	.140	.140	.140	.138
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.125	1.145		1.135	1.135	1.135	1.135	1.135
Y	1.565	1.585		1.575	1.575	1.577	1.575	1.575
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by: <i>Shashin Ladurikar</i>	Date: 17/12/06
Audited by: <i>M.P.</i>	Date: 17-12-11
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

DART AEROSPACE LTD		Work Order:	167805
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Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

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☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
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C	0.100	0.140						
D	0.210	0.230						
E	1.245	1.255						
F	1.245	1.255						
G	2.495	2.505						
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Q	3.715	3.725						
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S	0.240	0.270						
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U	1.625	1.635						
V	1.362	1.372						
W	0.316	0.321						
X	1.125	1.145						
Y	1.565	1.585						
Z	0.178	0.198						
AA								
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Accept/Reject								

Measured by:		Date:	
Audited by:		Date:	
Prototype Approval:	N/A	Date:	N/A

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